

shp feb. 20

Work Order ID 96190

January-24-13 7:58:52 AM

96190

Page 1

Item ID: D3700-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Inboard Window Doubler

Start Date: 1/24/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/01/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3700

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

6061 .080

4 0 Jm13-2-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm13-2-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
15
9-89

132 19

4

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Page 2

January-24-13 7:58:52 AM

Item ID: D3700-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Inboard Window Doubler
 Start Date: 1/24/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/01/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		76B-2-19	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		Smb 13219		4			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: STC63 Memo	0.00 0.00				4/x		SP 13-2-19.	

Work Order ID 96190***96190***

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Item ID: D3700-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Inboard Window Doubler

Start Date: 1/24/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/2/20 DJ

Q/B-0220

Picklist Print

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Work Order ID: 96190

Parent Item: D3700-1

Parent Item Name: Inboard Window Doubler

Start Date: 1/24/13

Required Date: 2/01/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

sf

292.0686

~~11605804~~

1.2

Jm 13-2-19

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

292.068632

117285

0.248632

119766

39.82

120096

168.8

123279

83.2

123279

SMC
 K. P. V.
 ENCLOSURE
 UNCONTROLLED COPY
 SUBJECT: 96190 MLJ
 VOLUME 1
 VOLUME 2

96190 MLJ

1301-25

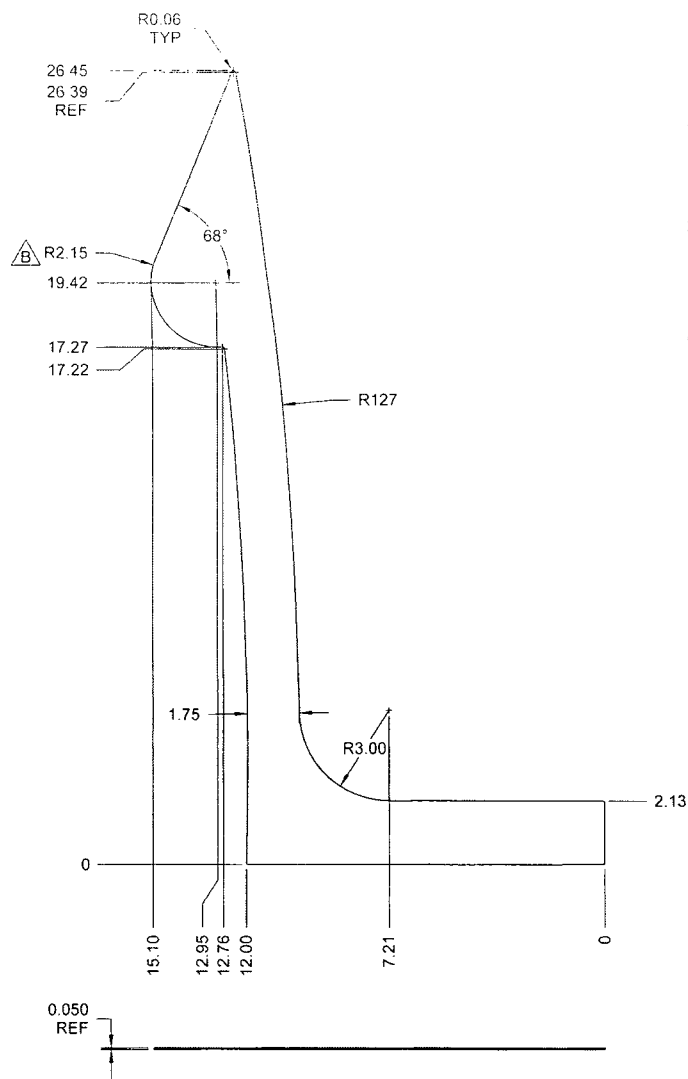
D3700-1 INBOARD WINDOW DOUBLER

D3700-3 OUTBOARD WINDOW DOUBLER

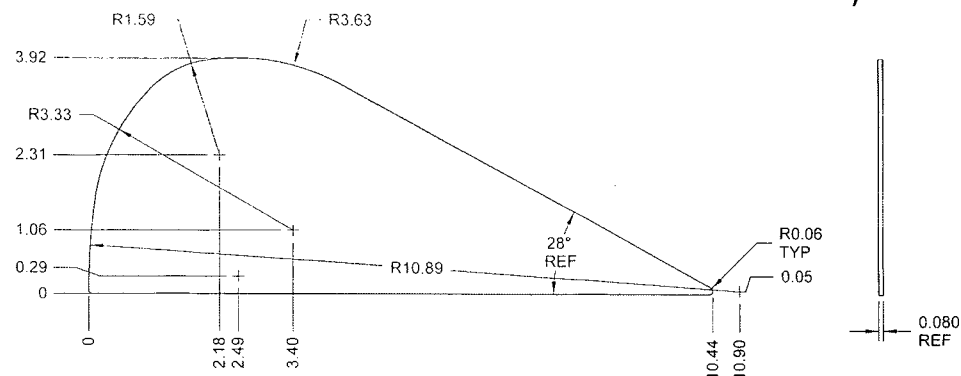
RELEASED
09/03/18

REV.	DESCRIPTION	BY	DATE
B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2); REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3700 TITLE WINDOW DOUBLER SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	09.03.18	REV. B SHEET 1 OF 2	

96190



D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

RELEASED
9/16/69

- NOTES:
- 1) MATERIAL:
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.37 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3700	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE WINDOW DOUBLER	SCALE
DE APPR.			NTS
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